

Date: Monday, 09/03/2009 1:42:12 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 46330	
Estimate Number : 11030	
P.O. Number :	Part Number : D2803042
This Issue : 09/03/2009 S.O. No. :	Drawing Number : D2803 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 41673	Material :
Written By :	Due Date : 23/03/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.03.09</u>	
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D28032

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-2	Bracket	B 44478 (2)

B 34032 (1) + B 46611 (7)

2.0

D28052

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	B 46374 (4)

46736 (6)

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B 46438

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:12 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46330

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/14 (10)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M110939

START TIME: 10:35

OVEN TEMPERATURE: 320°

FINISH TIME: 11:05

BL 09-04-14 (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-14 (X10)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803



09-04-14 (X10)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M1109147 (15X)

M111193 (5X)

09/04/14

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M111041

09/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46330

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

A/R LPS-3

Corrosion Spray

M109268

M109929

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

EP 09/04/14

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

EP 09/04/14 (10)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/14 (12)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST149

SS 09/04/14 (10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



mf 09-04-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

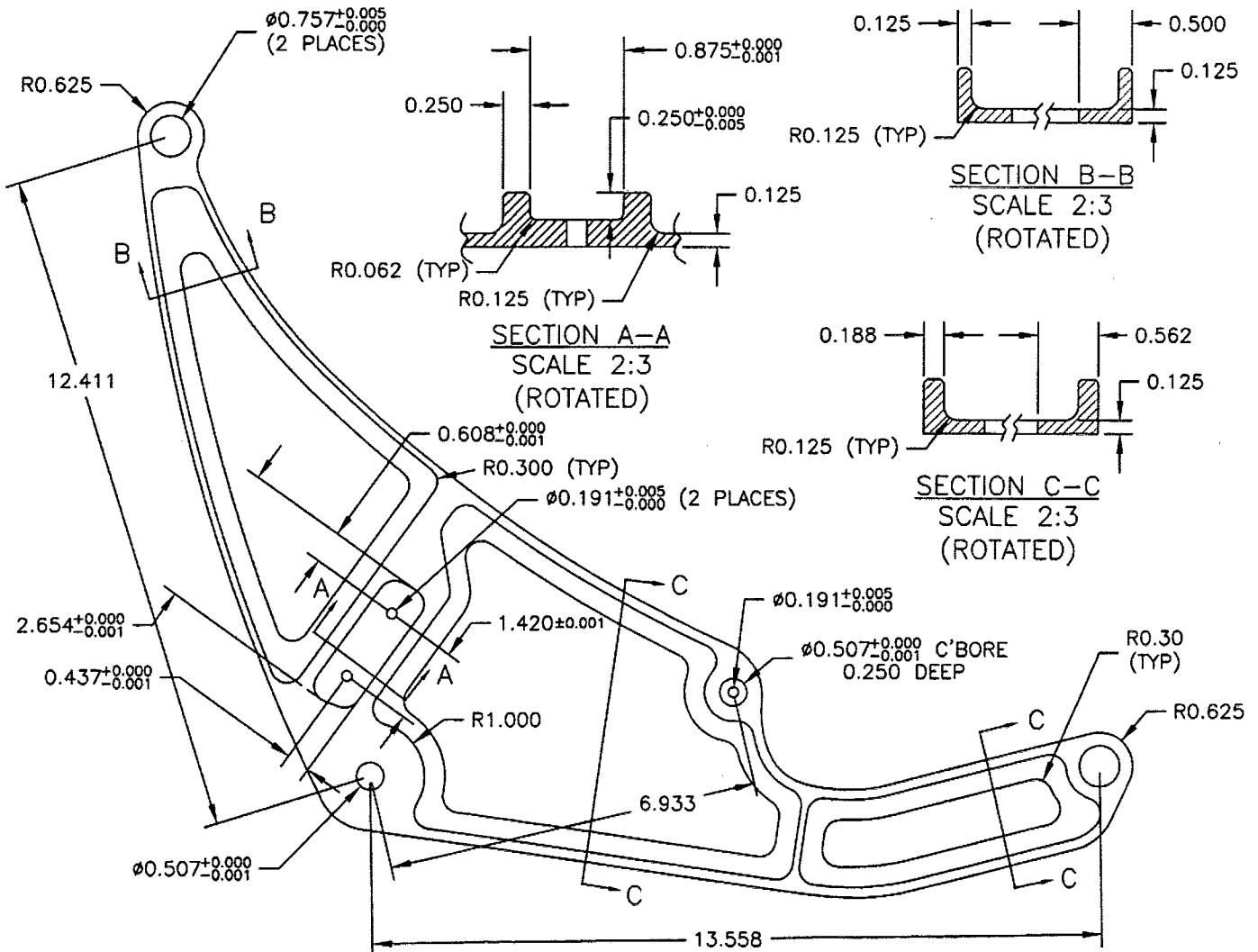
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D2803	SHEET 1 OF 2
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED05.03.11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

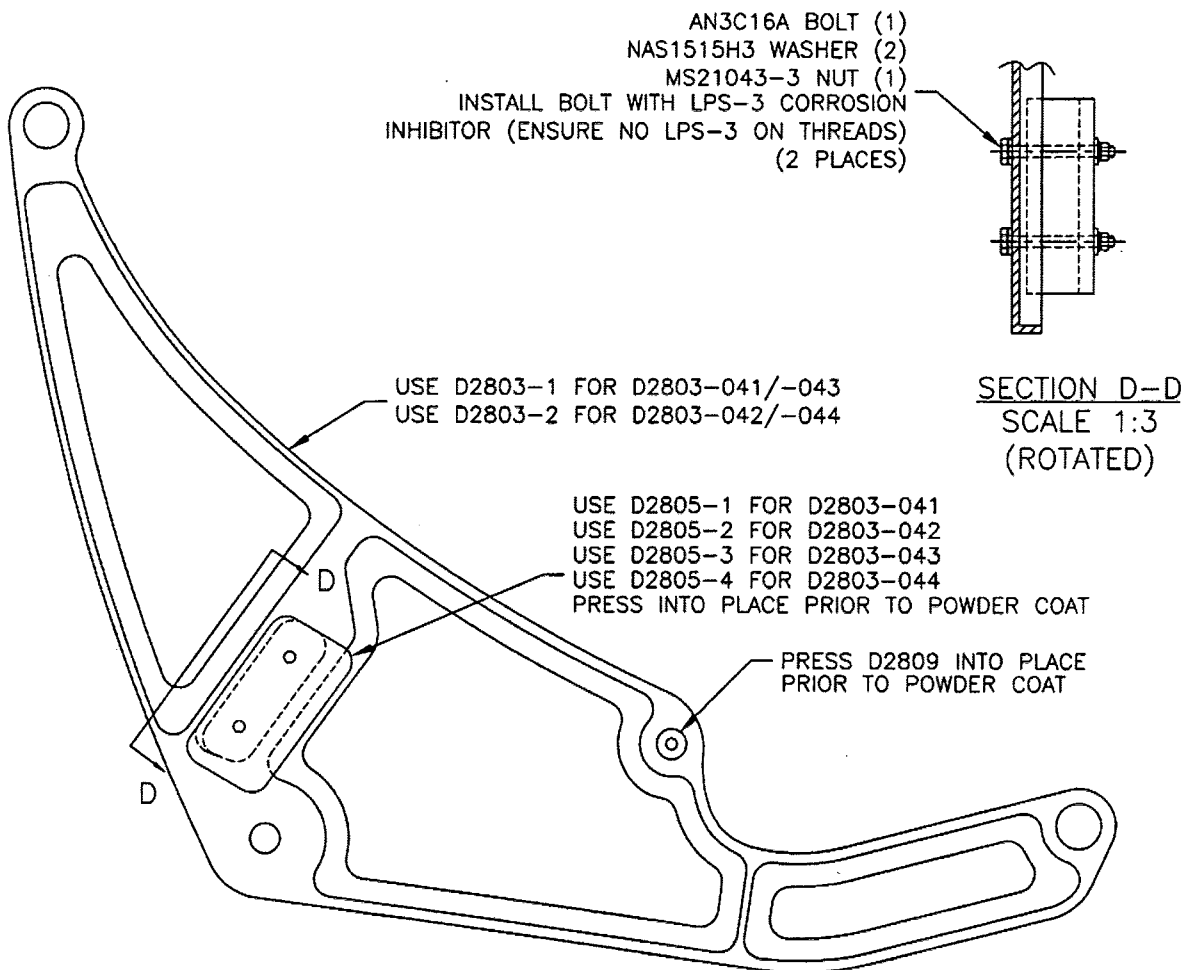
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WORK ORDER
NO. 46330

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE	04.11.22			TITLE STA 84 BRACKET	SCALE 1:3



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WORK ORDER

RELEASED

05.03.11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN) NO. *46330*

D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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